

Date: Monday, 28/04/2008 8:13:27 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEAR PLATE
Job Number :	38811		
Estimate Number :	11231		
P.O. Number :		Part Number :	D2348
This Issue :	28/04/2008	Drawing Number :	D2348 REV B2
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	B2
Previous Run :	31919	Material :	
Written By :		Due Date :	15/05/2008
Checked & Approved By :	JLD 08.4.28	Qty:	50 Um: Each
Comment :	Est Rev A Removed from 9 Digit 05-12-05 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0208 sf(s)/Unit Total: 1.0395 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Batch: 105205 RB 8-4-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2348
 Dwg Rev: B2 RB 8-4-30
 Prog Rev: B2

2-Deburr if necessary

55
 08/05/05 55 Nu

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508/05/05 55 cont

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

see step #2.2 08/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:27 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 38811

Part Number: D2348

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soedoster *count* *(55)*

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: _____

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Scrap

9.0

QC5

INSPECT WORK TO CURRENT STEP



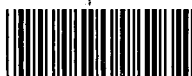
Comment: INSPECT WORK TO CURRENT STEP

INSPECT CERTS

10.0

FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert *10/634* *(22x)*

107897 *(198x)* *(22x)*

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

Bos/05/20

(55) *(24)*

12.0

QC5

INSPECT WORK TO CURRENT STEP


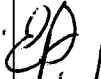

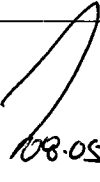


Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2348 PAR #: N/A Fault Category: Prod/Finishing NCR: (Yes) No DQA: DP Date: 08/05/29
 QA: N/C Closed: AP Date: 20/05/30

NCR: 38811		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0805-22	11.0	Inserts were pressed into the parts, and the parts were not anodized. Steps 7.0, 8.0 & 9.0 were not completed. R.C: Employee continued with the parts, when previous steps of work was not completed, lack of attention to the process.	 LS1012	<ul style="list-style-type: none">- Scrap & destroy all parts.- no replace.- Ensure to double check w/o for completeness before starting a step, and continuing the process.	 08/05/29	SB 08/05/29	 LS1012	 08-05-22

NOTE: Date & initial all entries

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Drawing Name: WEAR PLATE

Job Number: 38811

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

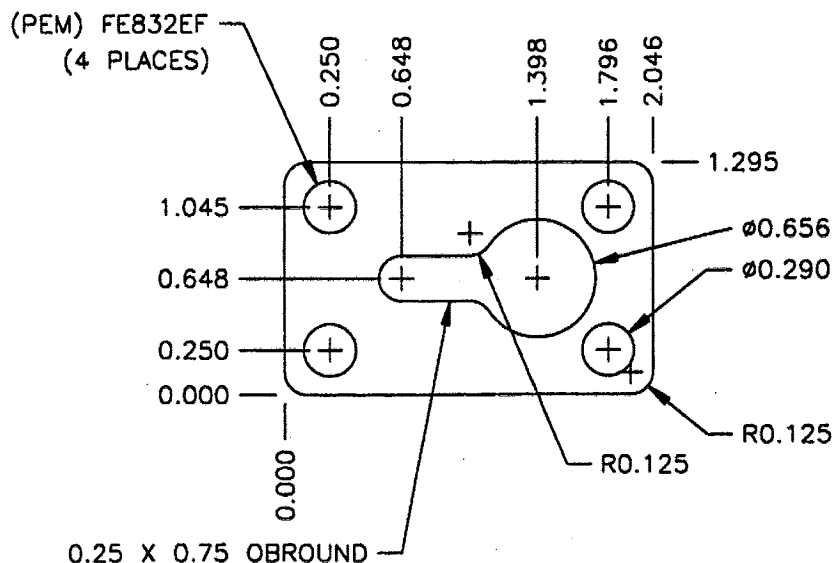
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	[Signature]	D2348	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		1:1
B	95:02:20	CHANGED PEM INSERT TO 8-32	
B1	00.03.07	CHANGE TO AISI 304/316 MATERIAL	
B2	02.02.21	CHANGE BACK TO 6061-T6	

RELEASED
97/04/22 DS



- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III/IV CLASS 2
 - 3) INSTALL FE832EF INSERTS AFTER ANODIZING
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER PART QSF 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38811

~~AISI 304/316 SS~~

~~MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES.~~